

Date: Tuesday, 24/03/2009 1:26:54 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ESCUTCHEON
 Job Number : 46678
 Estimate Number : 13836
 P.O. Number :
 This Issue : 24/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run :
 Written By : JLM 09.03.24
 Checked & Approved By :
 Comment : Est Rev: A New Issue 08-04-01 JLM Verified By: DD

Part Number : D37043
 Drawing Number : D3704 PREL B
 Project Number : N/A
 Drawing Revision : PREL B
 Material :
 Due Date : 31/03/2009 Qty: 2 Um: Each

09.05.27

PRELIMINARY ISSUE



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01250 6061-T6 Bar 1.50 x 1.25



NOT REMOVE FROM COMPUTER



Comment: Qty.: 0.2625 f(s)/Unit Total: 0.5250 f(s)
 6061-T6 Bar 1.500" x1.250"
 Batch: M110936

JLM 09/03/25 (2)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 3.00" long

JLM 09/03/25 (2)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA807 Rev: A & Dwg D3704 Rev: A

2-Deburr per dwg D3704

J.L 09/04/01

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/04/01

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
 APPROVAL

09.04.07 (2) JLM 09.04.03 (2)

Date: Tuesday, 24/03/2009 1:26:54 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ESCUTCHEON

Job Number: 46678

Part Number: D37043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



24

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 128

9/5/06

54

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

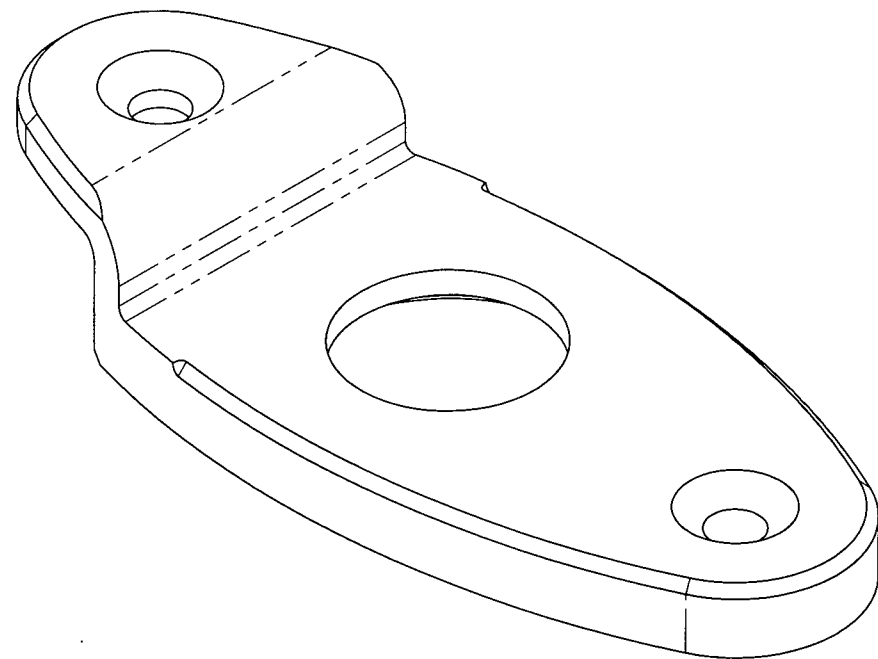
EFFECTIVE 09/05/26 AUTH 6

RELEASED 7

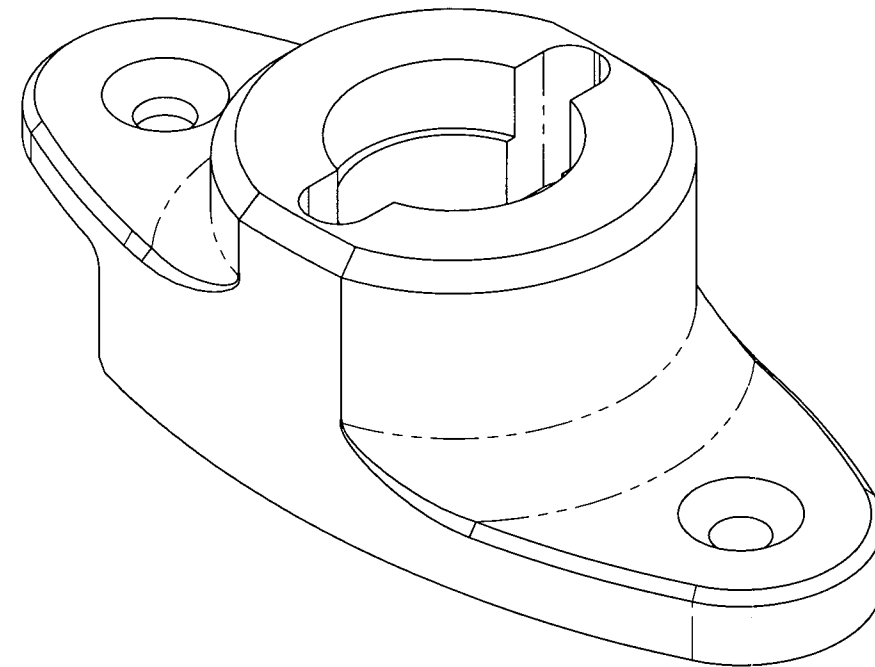
DATE

09.05.26

MF 09-05-27



D3704-1 ESCUTCHEON



D3704-3 ESCUTCHEON

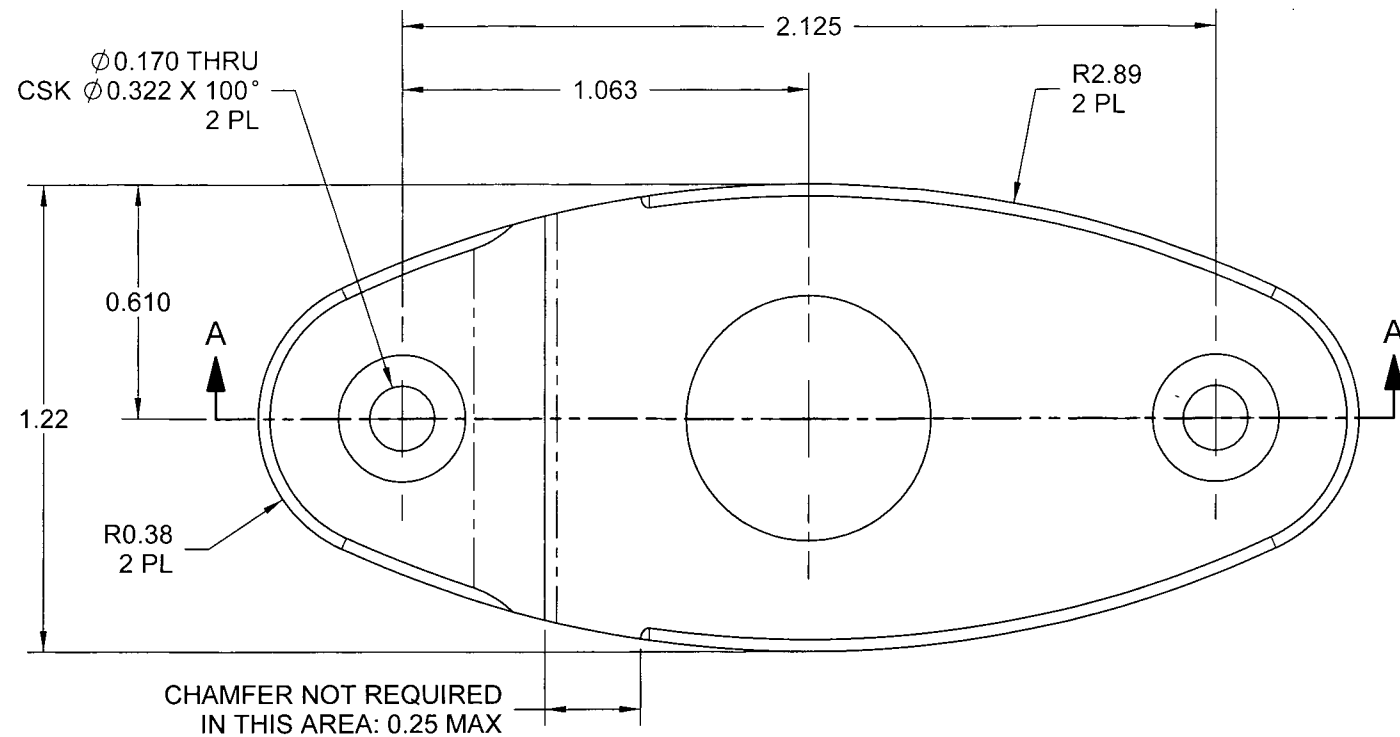
1" 207
W/ 46678

PRELIMINARY ISSUE
9.03.13

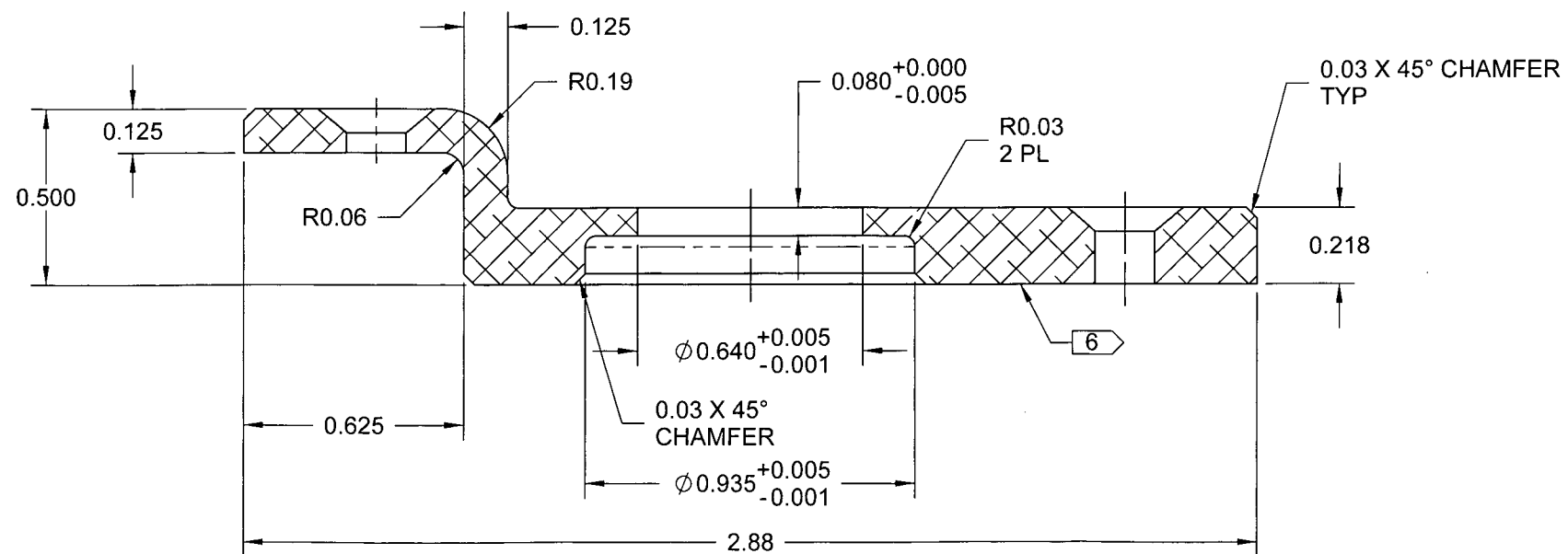
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3704-1 = 0.04 lbs
 - D3704-3 = 0.11 lbs

A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3704	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ESCUTCHEON	NTS
DATE	08.02.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3704-1 ESCUTCHEON

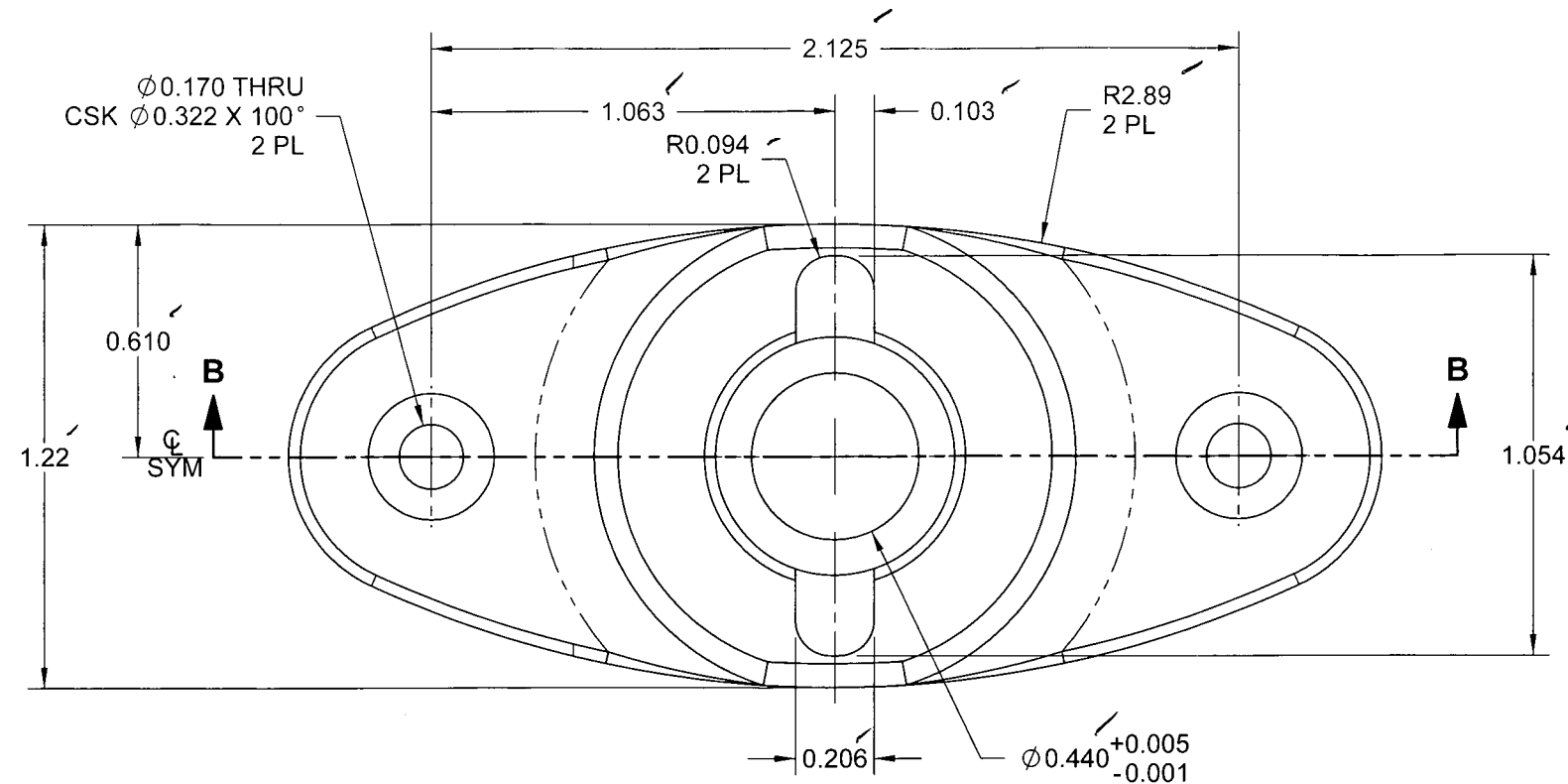


SECTION A-A

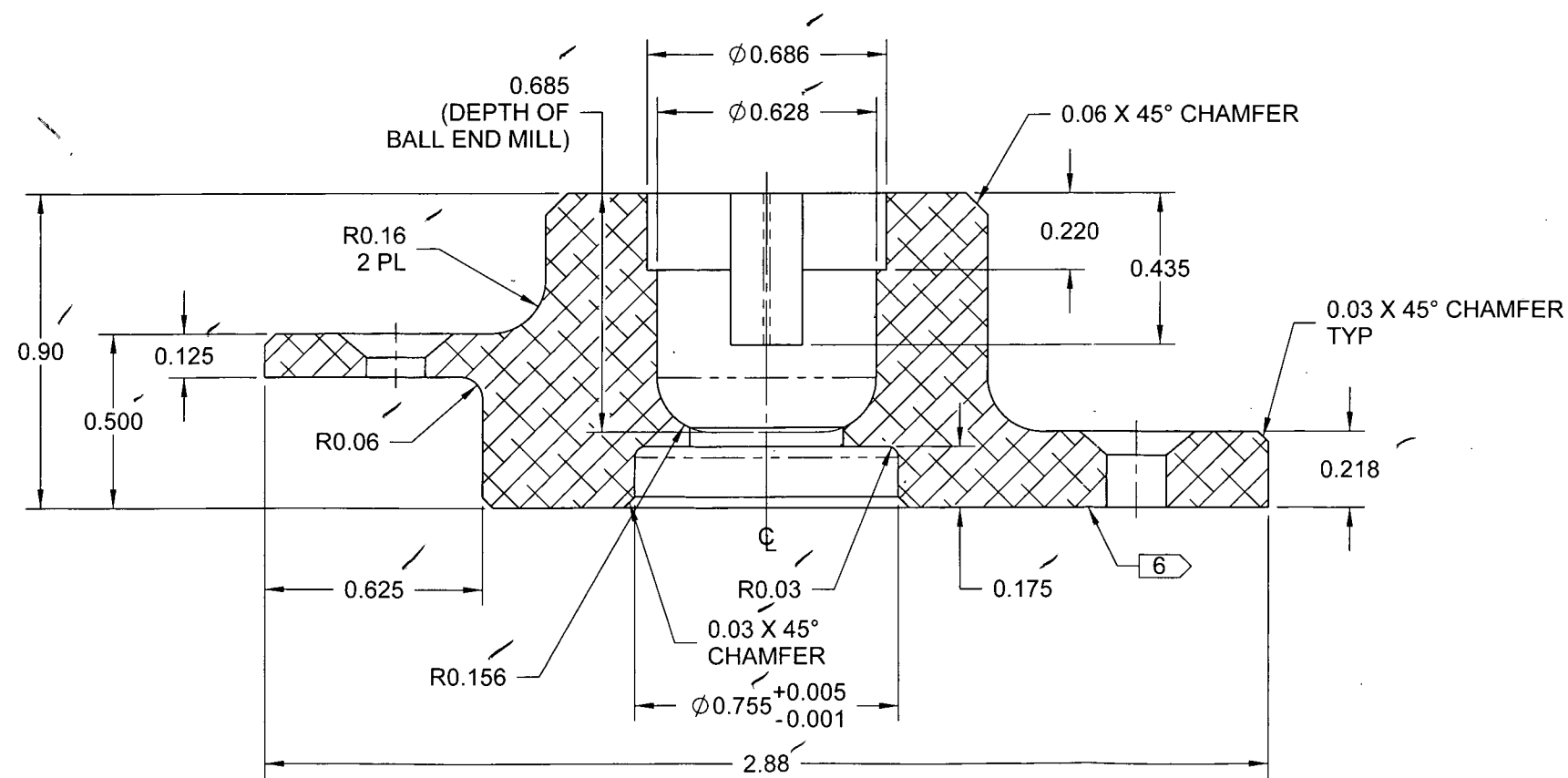
46678

PRELIMINARY ISSUE
09.05.13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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D3704-3 ESCUTCHEON



SECTION B-B

46678
PRELIMINARY ISSUE
09.03.13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3704	SHEET 3 OF 3
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DART AEROSPACE LTD		Work Order: 46678
Description: escutcheon		Part Number: D3704-3
Inspection Dwg: D3704	Rev: A B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

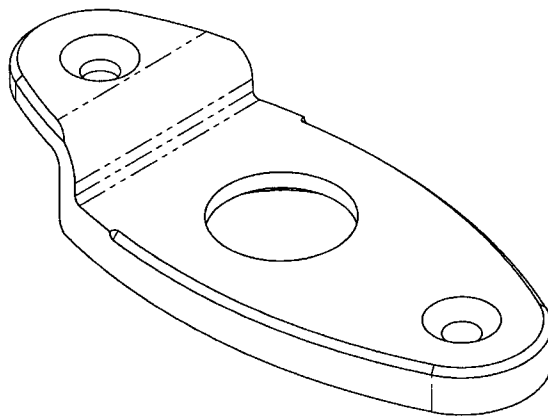
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	$\pm .030$	1.222	✓			
.610	$\pm .010$.611	✓			
.206	$\pm .010$.206	✓			
Ø.440	$\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix}$.442	✓			
1.054	$\pm .010$	1.052	✓			
2.125	$\pm .010$	2.124	✓			
1.063	$\pm .010$	1.063	✓			
Ø.170	$\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix}$.170	✓			
Ø.322x100°	$\begin{smallmatrix} \pm .010 \\ \pm .5^\circ \end{smallmatrix}$.332x100°	✓			
Ø.686	$\pm .010$.687	✓			
Ø.628	$\pm .010$.627	✓			
.90	$\pm .030$.899	✓			
.125	$\pm .010$.123	✓			
.500	$\pm .010$.500	✓			
1.06	$\pm .030$.06	✓			
.625	$\pm .010$.626	✓			
1.03	$\pm .030$.032	✓			
.03x45°	$\begin{smallmatrix} \pm .030 \\ \pm .5^\circ \end{smallmatrix}$.031x45°	✓			
Ø.755	$\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix}$.757	✓			
2.88	$\pm .030$	2.872	✓			
.175	$\pm .010$.174	✓			
.218	$\pm .010$.212	✓			
.435	$\pm .010$.436	✓			
.220	$\pm .010$.220	✓			

Measured by:	J.L.
Date:	09/04/01

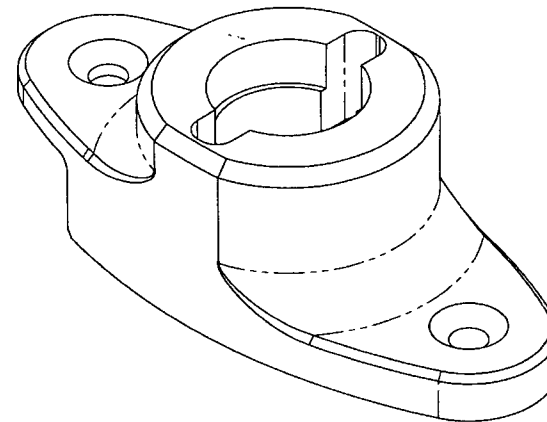
Audited by:	
Date:	01.04.03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3704-1 ESCUTCHEON



D3704-3 ESCUTCHEON

RELEASED
07/04/09

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
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- 7) WEIGHT:
 - D3704-1 = 0.04 lbs
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46678

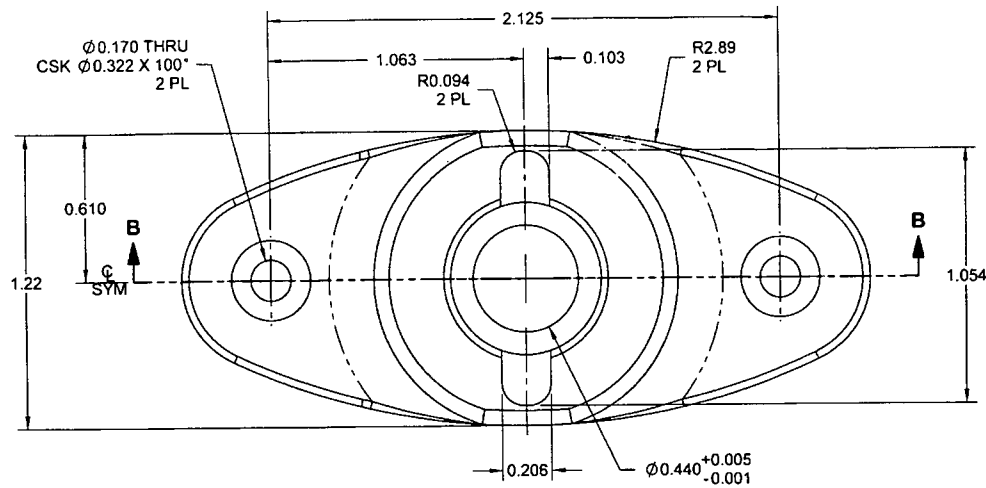
B	ADDED D3704-3. REASON: COMPATIBILITY WITH AAI'S HANDLE.	MB	09.03.17
A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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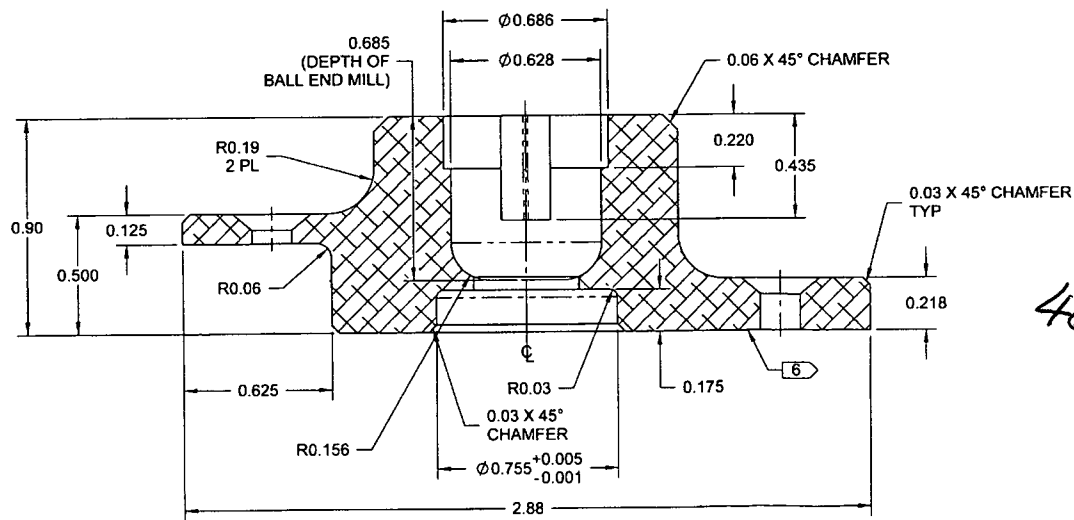
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RELEASED
09/04/09 MP

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MFG. APPR.	<i>[Signature]</i>	D3704	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3704-3 ESCUTCHEON



SECTION B-B

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09/04/09

46678